

Work Order ID 72846

Tuesday, August 16, 2011 10:50:28 AM



Page 1

Item ID: D3234-1

Revision ID: U/R

Item Name: Doubler

Start Date: 8/16/2011 Start Qty: 1.00

Required Date: 8/16/2011 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: *MWP*

Date: 8-16 Tooling:

PRELIMINARY ISSUE

QC:

Date: SPC (Y/N):

Date:

Date:

Sequence ID/
Work Center IDOperation
Description

Draw Nbr

Revision Nbr

D3234

pcl

100



FLOW WATER JET

Waterjet

FLOW CNC Waterjet

2024 .050

110



QC

Quality Control

120



QC

Quality Control

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop

Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 72846

Tuesday, August 16, 2011 10:50:28 AM



Page 2

Item ID: D3234-1

Accept



Setup Start



Revision ID: U/R

Stop



Item Name: Doubler

Start Date: 8/16/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 8/16/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Chemical Conversion Coat per QSI005 4.1

0.00

2x Ø M/L 11/08/17

HandFinish

Hand Finishing

140



QC3- Inspect Part Finish

0.00

2 Ø M/L 11/08/17

QC

Quality Control

150



Identify as per dwg & Stock Location:

0.00

11/8/17 S 20

Packaging

Packaging

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/11/25	#170	Now at Rev C day. Design change.	S 11/11/25 057042	Scrap + Destroy QH +2	S 11/11/25	S 11/11/25 057042 11/11/25	S 057042 11/11/25	S 11/11/25

NOTE: Date & initial all entries

Work Order ID: 72846

Tuesday, August 16, 2011 10:50:28 AM



Page 3

Item ID: D3234-1

Revision ID: U/R

Item Name: Doubler

Start Date: 8/16/2011 Start Qty: 1.00

Accept



Setup Start



Stop



Required Date: 8/16/2011 Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

QC: _____

Date: _____

Tooling: _____

Date: _____

SPC (Y/N): _____

Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
Description

160

QC21- Final Inspection - Work Order Release



QC

Quality Control

Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

0.00

X

POSITIVE RECALL
EFFECTIVE _____ **AUTH** _____
RELEASED _____ **DATE** _____

MF
11-11-25

Memo

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, August 16, 2011 10:50:25 AM

Page 1

Work Order ID: 72846



Parent Item: D3234-1



Parent Item Name: Doubler

Start Date: 8/16/2011

Required Date: 8/16/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 08-08-14 JLM Verified By:EC
IPP Rev:B 08-12-18 as per ECN08-582 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S050		Purchased	No			100	sf	97.4000	0.579	0.609474	1.5	B11-8-17	

2024-T3 050 sheet

Location	Loc Qty	Loc Code
MAT22	97.4	
117684	97.4	117684

(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD

Work Order: 72846

Description: Dangler

Part Number: D3234-1

Inspection Dwg. D3234-1, Rev: U/R PC1

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

 First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Φ .698	+.004 - .001	.694	✗		V (B02)	
.250	+/- .010	.247	✗		V	
2.270	+/- .010	2.268	✗		V	
2.747	+/- .010	2.747	✗		V	
.266	+/- .010	.264	✗		V	
.300	+/- .010	.301	✗		V	
2.627	+/- .010	2.629	✗		V	
5.993	+/- .010	5.995	✗		V	
7.108	+/- .010	7.102	✗		V	
8.228	+/- .010	8.230	✗		P (Row 502)	
10.463	+/- .010	10.469	✗		P	
10.77	+/- .030	10.77	✗		P	
2.25	+/- .030	2.249	✗		V	
13.333	+/- .010	13.333	✗		T (B01)	
15.365	+/- .010	15.365	✗		T	
15.665	+/- .010	15.668	✗		T	
1.23	+/- .030	1.23	✗		V	
2.739	+/- .010	2.741	✗		V	
2.970	+/- .010	2.972	✗		V	
3.168	+/- .010	3.170	✗		V	
3.308	+/- .010	3.310	✗		V	
4.553	+/- .010	4.550	✗		V	
.050	+/- .010	.050	✗		V	

Measured by:	KB
Date:	11-8-16

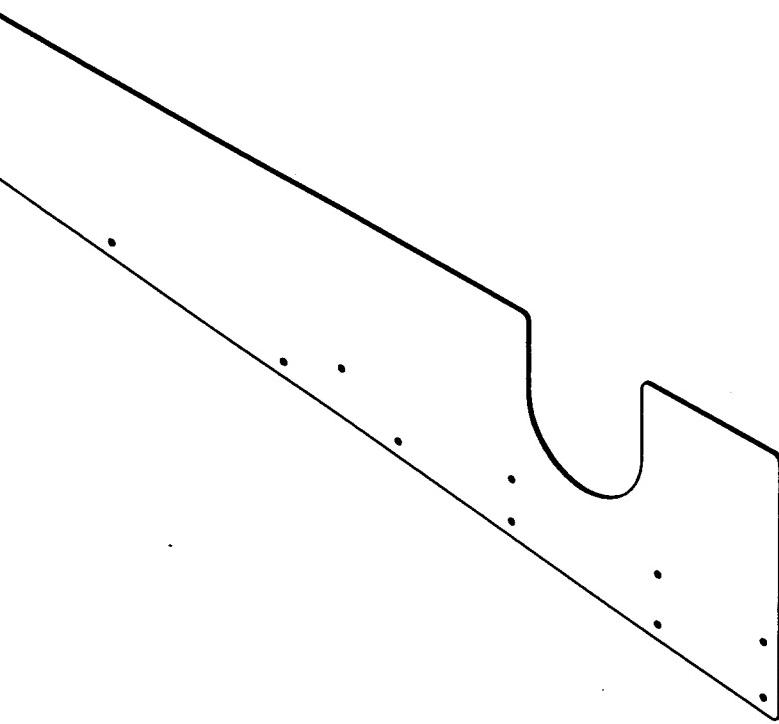
Audited by:	S
Date:	11/08/16

Prototype Approval:	
Date:	

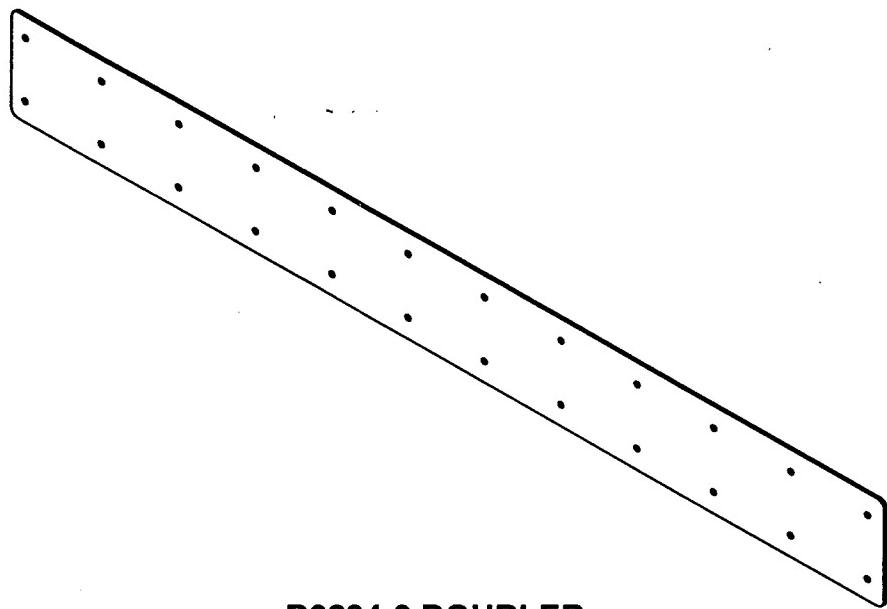
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

8 7 6 5 4 3 2 1

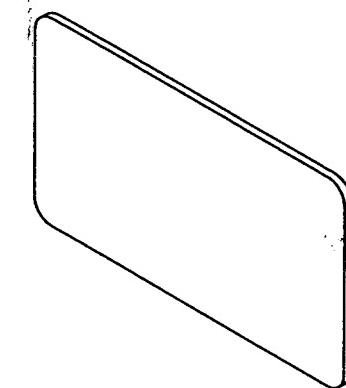
D



D3234-1 DOUBLER



D3234-3 DOUBLER



D3234-5 SPACER

PRELIMINARY ISSUE

Rev PC1

CP
11.08.16

NOTES:

- 1) MATERIAL: -1 & -3: 2024-T3 ALUMINUM SHEET, 0.050 THICK PER AMS-QQ-A-250/4 OR AMS 4037 REF DART SPEC M2024T3S.050
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3234-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: -1: 0.26 lbs
-3: 0.15 lbs
-5: 0.01 lbs



C	REDESIGN -1 TO MATCH D3025-1: 4.553 WAS 5.347 (C3-2), 2.747 WAS 2.841 (D8-2), REF. PAR 11-118	CP	11.08.15
B	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. PARTS FULLY DIMENSIONED. NO PHYSICAL CHANGES MADE TO PARTS. REASON: REF PAR 08-029.	AJS	08.11.24
A	NEW ISSUE	CP	03.11.19
REV	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD	
DRAWN	CP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RS	DRAWING NO.	PC1
MFG. APPR.	RS	REV. C	SHEET 1 OF 2
APPROVED	MP	TITLE	DOUBLER
DE APPR.		SCALE	NTS
DATE	11.08.15	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8

7

6

5

4

3

2

1

D

C

B

A

C

